

Date: Monday, 7/9/2007 11:47:31 AM
User: Kim Johnston

Process Sheet

SPLT-1

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT WEB
 Job Number : 33373
 Estimate Number : 10791
 P.O. Number : N/A Part Number : D3282041
 This Issue : 7/9/2007 S.O. No. : N/A Drawing Number : D3282 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 33224 Material : N/A Due Date : 7/20/2007 Qty: 2 Um: 8 Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: B 05.09.23 Procedure change KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D2792130 EXTRUSION



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2792-130

Extrusion

B24030

Identify as D3282-1

DP 7-7-12

(8)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

DP 7-7-12

(8)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

mk 07/07/17

2

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 07/07/17

2

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mk 07/07/18

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33373

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

K 7-7-18 (2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

K 7-7-18 (2)

8.0

D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3283-1

Doubler

B32477 (4)

K 7-7-18

9.0

MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total: 456.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

57 MS20470AD4-7

Rivet

M100854 (114)

K 7-7-18

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 M103674

K 7-7-18 (2)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-7-18 (2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

4/6 DP 7-7-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT WEB

Job Number: 33373

Part Number: D3282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33373
Description: Float Web		Part Number:	D3282-041
Inspection Dwg: D3282	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

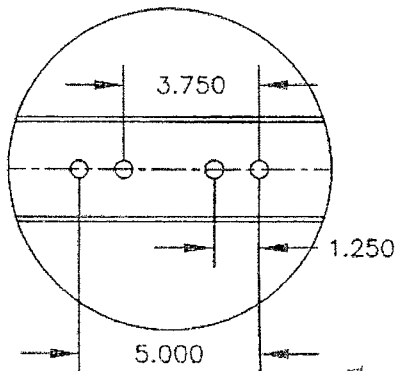
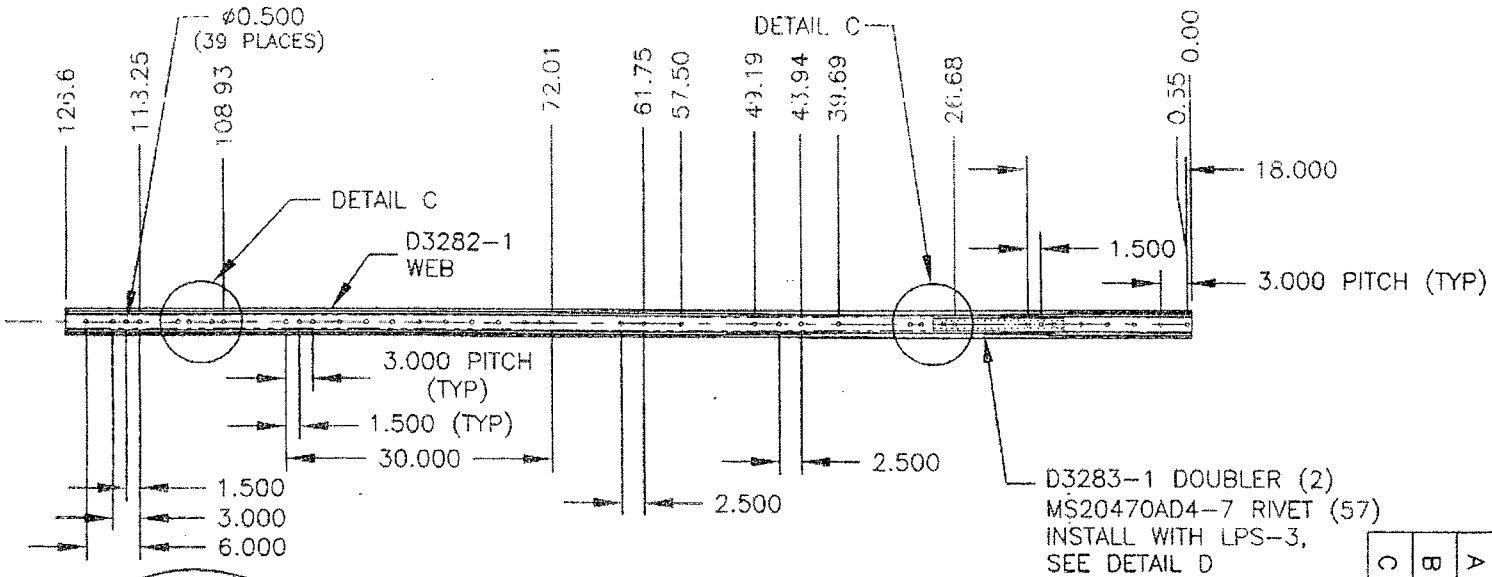
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
126.6	+/-0.100	126.620	—			
1.500	+/-0.010	1.500	—			
3.000	+/-0.010	3.000	—			
6.000	+/-0.010	6.000	—			
1.250	+/-0.010	1.250	—			
30.000	+/-0.010	30.000	—			
1.500	+/-0.010	1.500	—			
72.01	+/-0.030	72.000	—			
31.75	+/-0.030	31.750	—			
57.50	+/-0.030	57.500	—			
49.19	+/-0.030	49.190	—			
43.94	+/-0.030	43.930	—			
39.69	+/-0.030	39.680	—			
26.68	+/-0.030	26.680	—			
0.55	+/-0.030	0.550	—			
1.970	+/-0.010	1.971	—			
2.38	+/-0.030	2.380	—			
0.05	+/-0.030	0.055	—			

Measured by:	<i>gmk</i>	Audited by:	<i>En</i>	Prototype Approval:	N/A
Date:	07/07/17	Date:	07/07/17	Date:	N/A

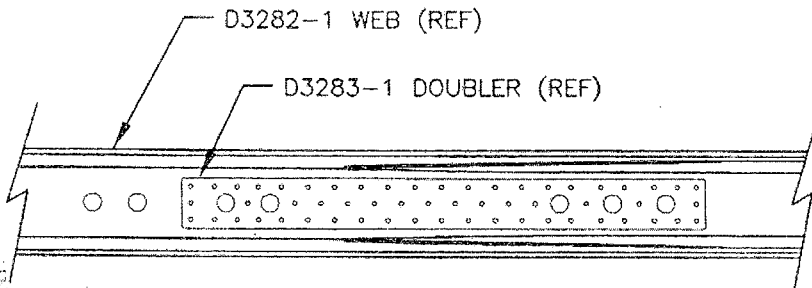
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signature]</i>

DAFT

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D3282	SHEET 1 OF 2
DATE				TITLE	SCALE
05.08.09				FLOAT WEB, 206L/407	1:20
A	04.05.05			NEW ISSUE	
B	05.03.16			MOVE HOLES, ADD D3390-1 DOUBLERS	
C	05.08.09			REMOVE D3390-1, NOW MACHINED	



DETAIL C
SCALE 1:5
RIVET HOLES NOT SHOWN
FOR CLARITY



DETAIL D
SCALE 1:5

RELEASED
05-21-12

D3282-041 FLOAT WEB

- 1) MAKE FROM D2792-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) APPLY A LAYER OF LPS LABORATORIES' LPS-3 BETWEEN D3283-1 DOUBLERS AND D3282-1 WEB. INSTALL RIVETS COATED WITH LPS-3
- 6) SEE PAGE 2 FOR MACHINING DETAILS

Copyright © 2004 by DART AEROSPACE USA, INC.

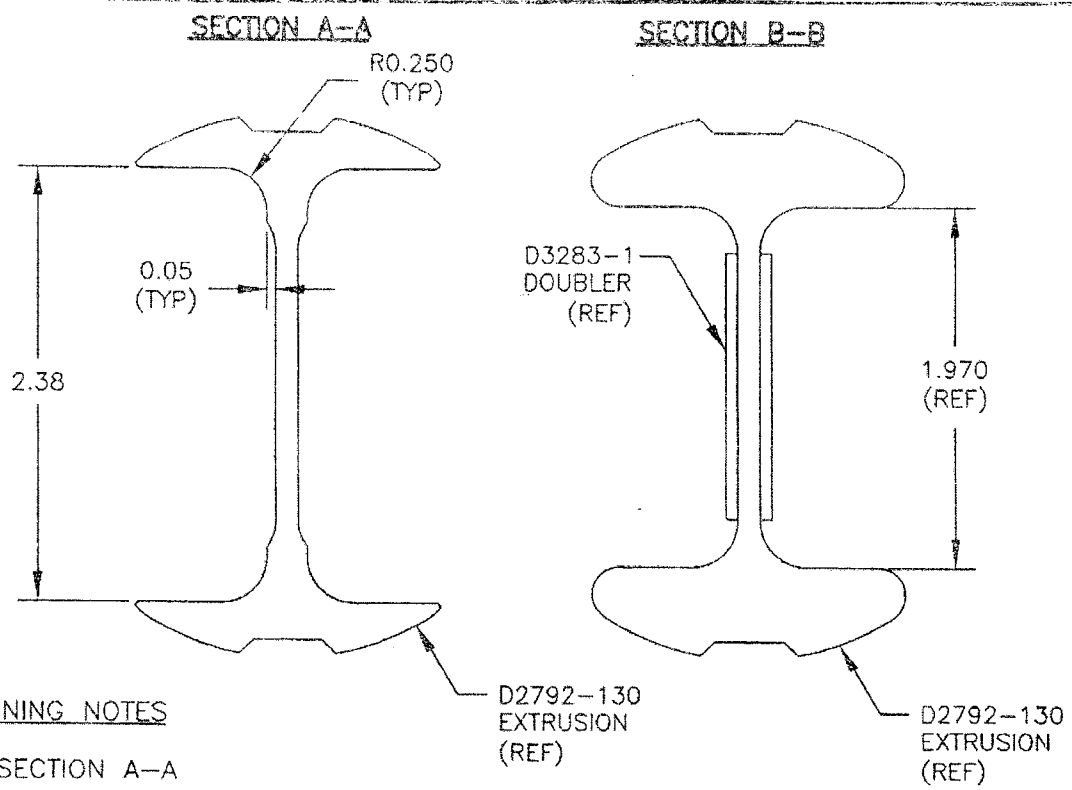
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2004 by DART AEROSPACE USA, INC.

DAFT

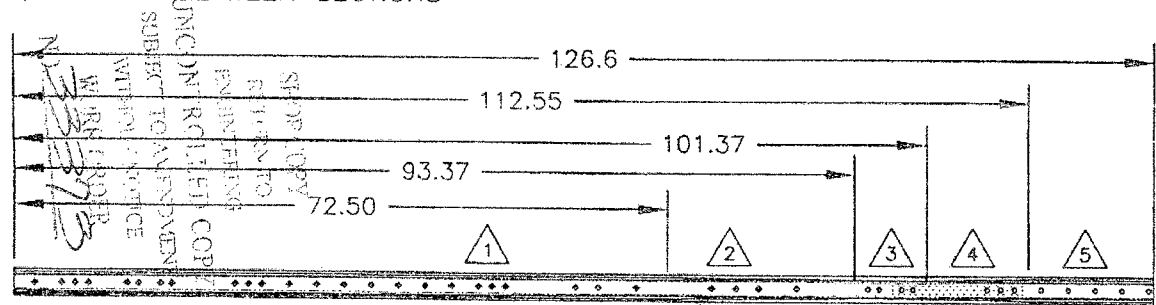
DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. 0
				D3282	SHEET 2 OF 2
DATE	05.08.09			TITLE	SCALE
				FLOAT WEB, 206L/407	1:20

2005-04-12



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A (REF)
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Copyright © 2004 by DART AEROSPACE USA, INC.